

Work Order ID 52966

October 20, 2009 7:15:42 AM

SHIP TODAY

Page 1

Item ID: D3655-3

Accept

Setup Start

Revision ID: B

Stop

Item Name: PANEL

Start Date: 10/20/09 Start Qty: 1.00

Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *N*

Date: _____

Tooling: _____

Date: _____

Run Start




QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3655	Rev B								
100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks to fit frame size								
110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT 8985 <input checked="" type="checkbox"/> Dwg. Rev. <i>3</i> <input type="checkbox"/> Folio Rev. <i>A</i>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								

BB
09/10/20
(1)

BB
09/10/20
(1)

BB
09/10/20
(1)

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Item ID: D3655-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 10/20/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00



QC Memo 0.00

Quality Control

DL 09/10/20 (X1)

140 HAND FINISHING THERMOFORMING 0.00



Thermoform Memo 0.00

Thermoforming Machine Trim to Finished Dimensions as per dwg D3655

DL 09/10/20 (X1)

150 QC2- Inspect parts off machine FAI/FAIB 0.00



QC Memo 0.00

Quality Control Check dimensions to ensure conformity to drawing tolerances.

DL 09/10/20 (X1)

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Item ID: D3655-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 10/20/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 on 10/20

② f

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

MF 09-10-20.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/20
MF 09-10-20

Picklist Print

October 20, 2009 7:15:41 AM

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Work Order ID: 52966

Parent Item: D3655-3RevB

Parent Item Name: PANEL

Comments:

Start Date: 10/20/09

Required Date: 10/20/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,357.812	34.6600			
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1357.812653

107574

16.62

111973

190.526053

112176

1150.6666

09/10/20

3B

DART AEROSPACE LTD		Work Order:	
Description: Panel		Part Number:	D3655-3
Inspection Dwg: D3655	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/10/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9	+/-0.100	<u>67.879</u>	✓		<u>TAPE</u>	
25.0	+/-0.100	<u>25.0</u>	✓		<u>TAPE</u>	
44.5	+/-0.100	<u>44.5</u>	✓		<u>TAPE</u>	
0.070	Min	<u>0.088</u>	✓		<u>Visual</u>	
0.050	Min	<u>0.057</u>	✓		<u>Visual</u>	

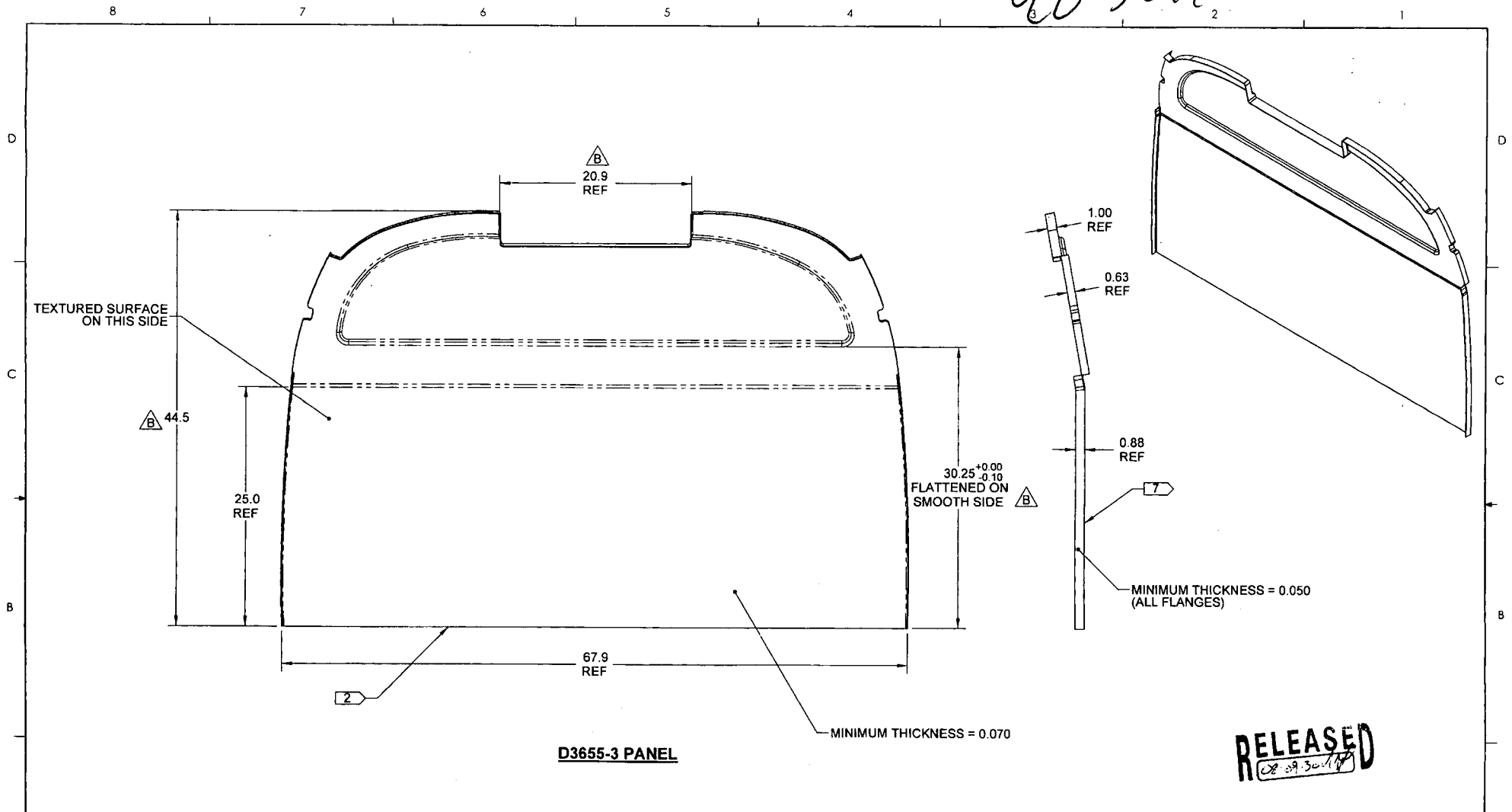
Measured by: DR Date: 09/10/20

Audited by: BB Date: 09/10/20

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ <u>BB</u>	<u>BB</u>

NO 52966

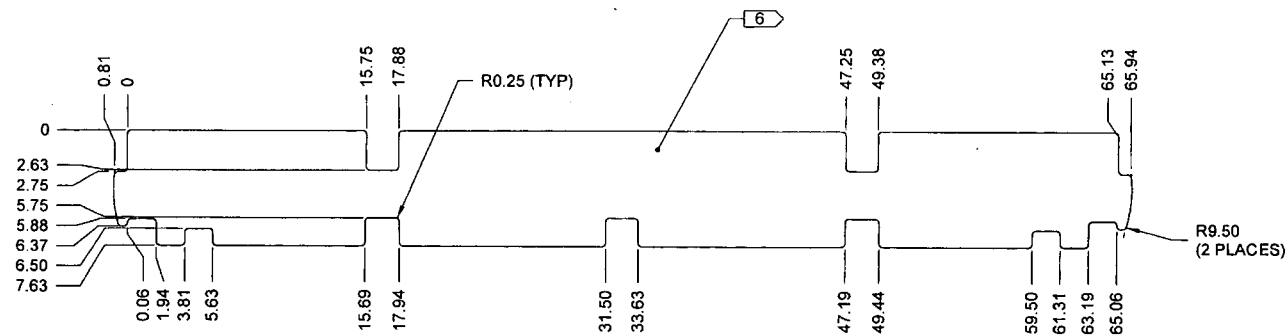


D3655-3 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022
TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 10.8 lbs

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	IR	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.06.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/052966



D3655-1 PANEL

RELEASED
08.09.30/17

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3655	SHEET 1 OF 2
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	PANEL	NTS
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